

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023690**Date Inspected:** 13-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Sun Tian Liang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 009119

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13B/CE. The weld designations reviewed are as follows:

1. SEG3009-002, 003
2. SEG3011-002

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SA3127-020~033-009 and 011 located on bottom plate connected SA3127 at panel point 124 to 124.5 FL2 side of OBG Segment 13CW. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

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FCAW welding of weld joint SA3128-001~002-001, 004, 007 and 010 located on bottom plate connected SA3128 at panel point 124 to 124.5 FL2 side of OBG Segment 13CW. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint SA3133-001~005-001 and 003 located on corner assembly edge plate connected SA3133 at panel point 124 to 124.5 FL3 side of OBG Segment 13CW. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SA3132-001~005-001 and 003 located on corner assembly edge plate connected SA3132 at panel point 121 to 121.5 FL3 side of OBG Segment 13CW. ZPMC Welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014S-042~051 located on vertical plate RS stiffeners to floor beam at panel point 121.5 of OBG Segment 13BW. ZPMC Welders are identified as 040270 and 069896. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint SEG3014B-010 located on vertical plate to floor beam at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020S-111 located on vertical plate to floor beam at panel point 125.5 of OBG Segment 14W. ZPMC Welder is identified as 037932. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020T-129 located on bottom plate I-ribs to floor beam at panel point 125.5 of OBG Segment 14W. ZPMC Welder is identified as 067572. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

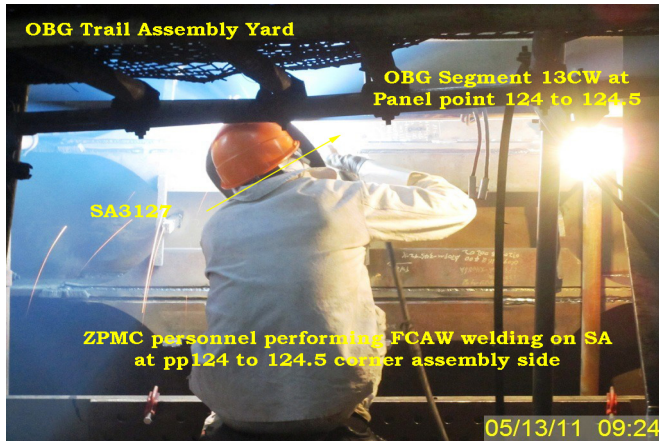
FCAW welding of weld joint SEG3020X-077, 078 and 079 located on longitudinal diaphragm to floor beam I-ribs at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067572. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-ESAB.

Please see the attached pictures.

general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer